

Date: Tuesday, 22/07/2008 11:25:19 AM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY RH  
 Job Number : 40700  
 Estimate Number : 10265  
 P.O. Number :  
 This Issue : 22/07/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D350636012  
 First Issue : / / Type : SKIDTUBES Drawing Number : D2750 UNDER REVIEW  
 Previous Run : 39764 Drawing Revision :  
 Material :  
 Due Date : 10/08/2008 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : Julie Lecocq 08.7.22  
 Comment :  
 Est Rev: I 02.09.25 Rearranged procedure steps KJ  
 Est Rev: J 06-03-29 As per Rev D EC  
 Est Rev: K 06-07.13 As per dsi9343 EC  
 Est Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM  
 Verified By: EC  
 Est Rev: M 08-04-22 update steps 4,13 DD verified by: EC

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

DC

DOCUMENT CONTROL



8 8/0/7



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-012 CHG 004 + DSI 9413 08.07.22

2.0

D26003BENT

Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-3-Bent

Extrusion (Bent)

39714

SL 6-7-28

3.0

D2744

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch: 37768

BE 08-07-29

4.0

SKIDTUBES 1

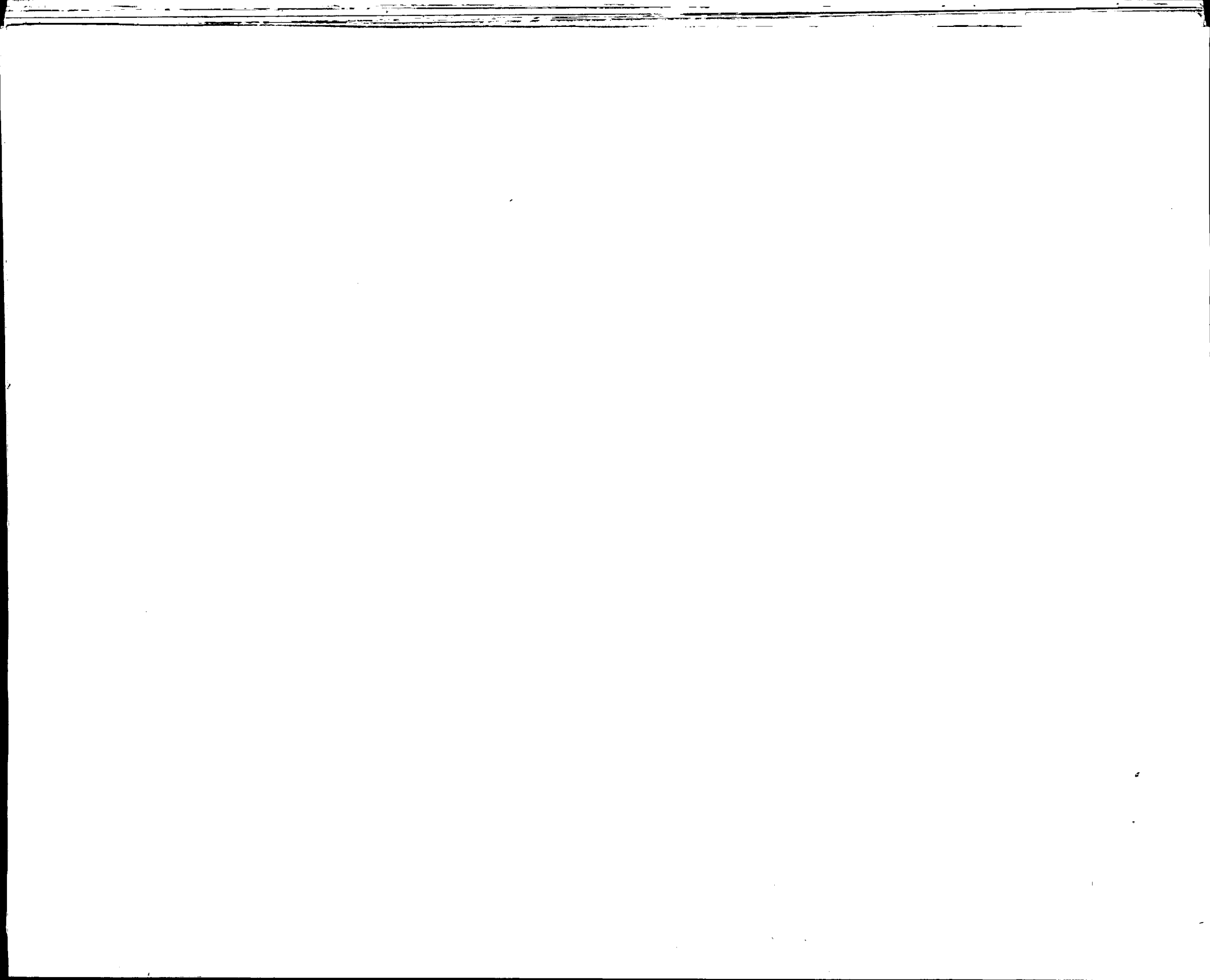
SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details). Drill using drill Jig DT8150 &amp; DT8863.



33

Date: Tuesday, 22/07/2008 2:01:06 PM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY RH  
 Job Number : 40700  
 Estimate Number : 10265  
 P.O. Number :  
 This Issue : 22/07/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D350636012  
 First Issue : 22/07/2008 Type : SKIDTUBES Drawing Number : D2750 UNDER REVIEW  
 Previous Run : 39764 Project Number : N/A  
 Drawing Revision :  
 Material :  
 Due Date : 10/08/2008 Qty: 1 Um: Each

Written By : \_\_\_\_\_

Checked & Approved By : \_\_\_\_\_

Comment : Est Rev:I 02.09.25 Rearranged procedure steps KJ  
 Est Rev:J 06-03-29 As per Rev D EC  
 Est Rev:K 06-07.13 As per dsi9343 EC  
 Est Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM  
 Verified By:EC  
 Est Rev:M 08-04-22 update steps 4,13 DD verified by:EC

REFERENCE ONLY

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JLD 08/8/7



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-012 CHG 004

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2600-3-Bent Extrusion (Bent)

3.0 D2744 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: \_\_\_\_\_

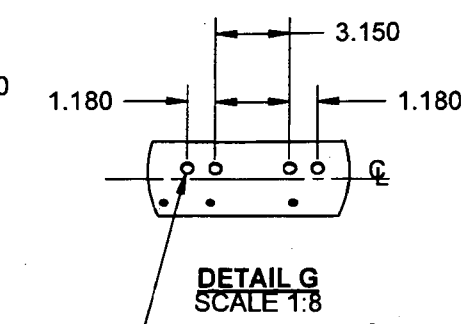
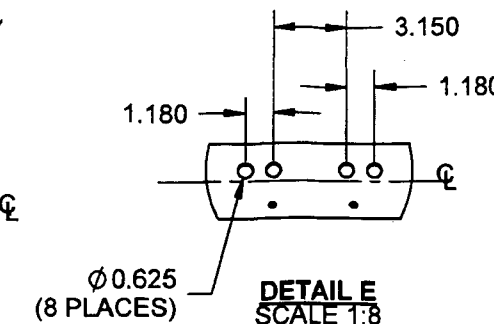
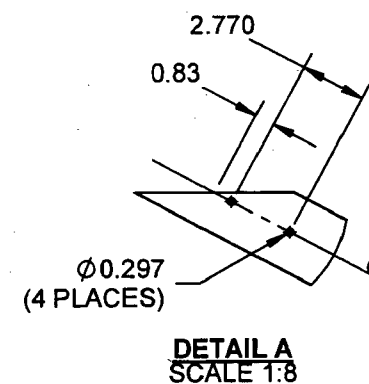
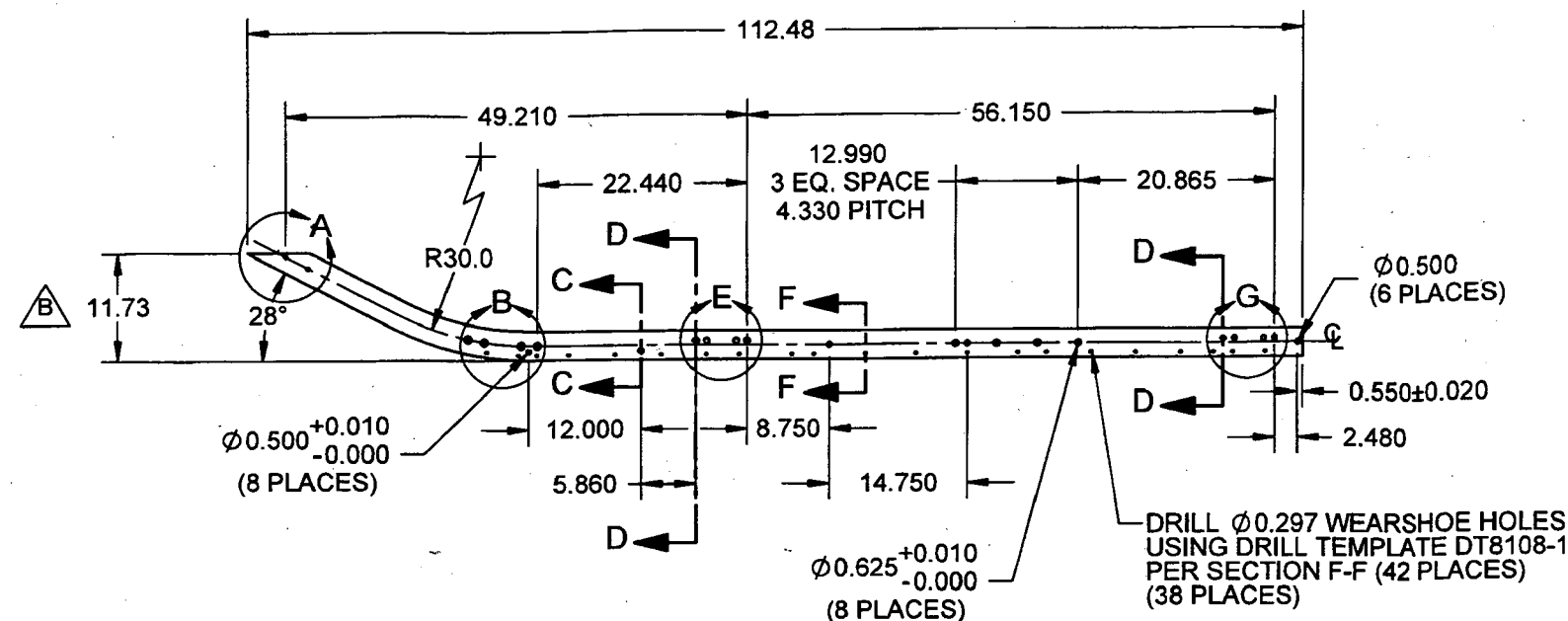
4.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



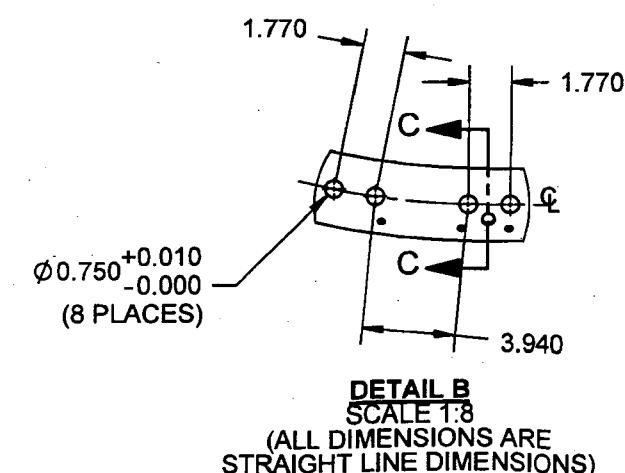
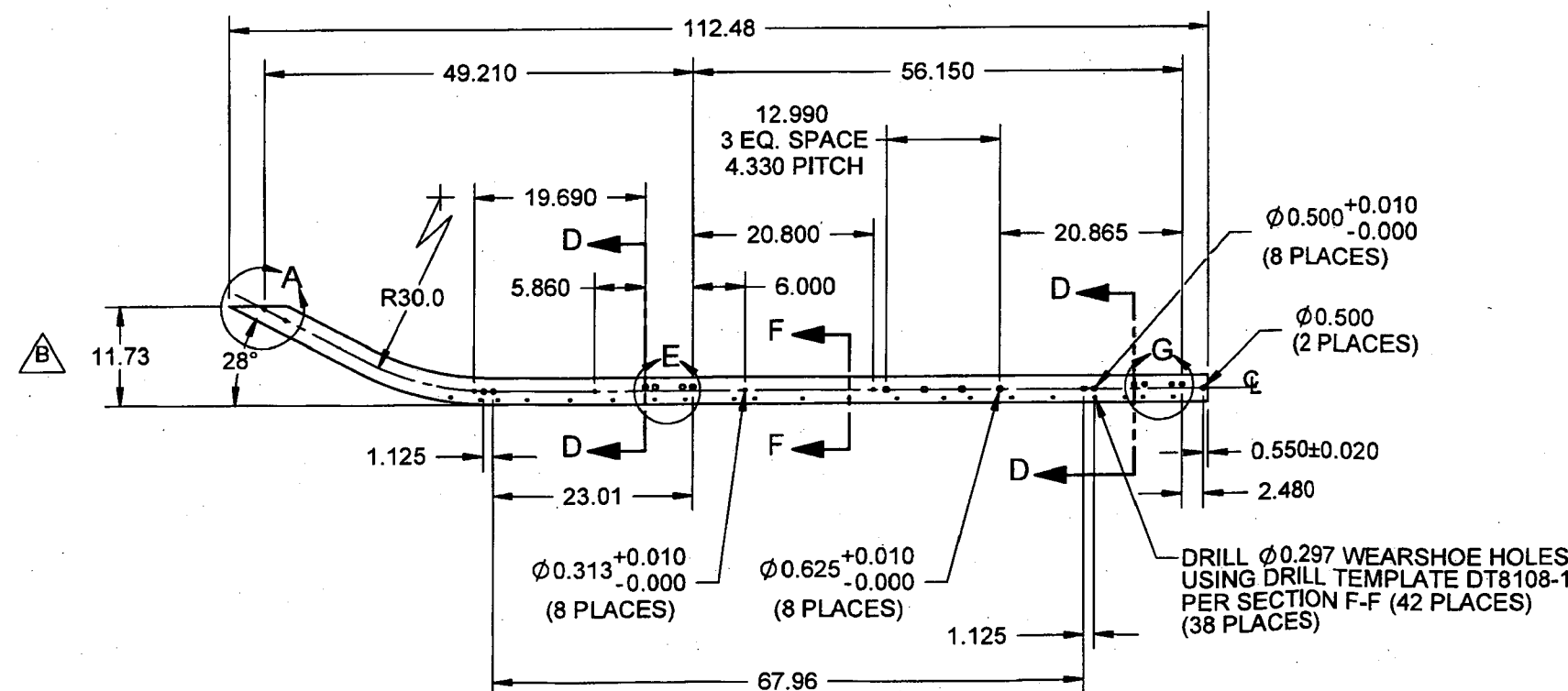
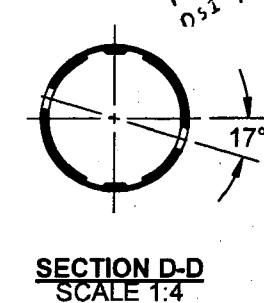
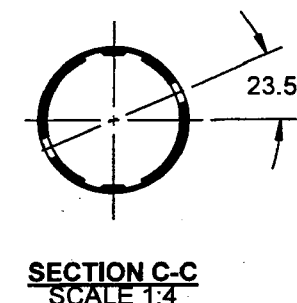
Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

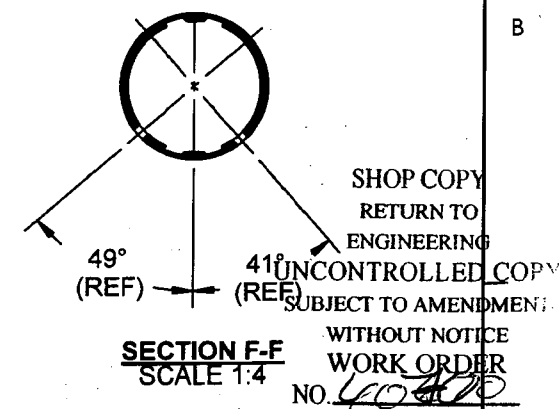
2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details).Drill using drill Jig DT8150 & DT8863 .




PH 03.02.22  
 UNDER REVIEW  
 03.06.27  
 UPDATE  
 PER  
 0519419

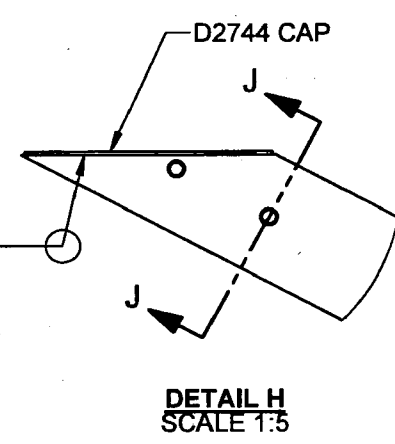
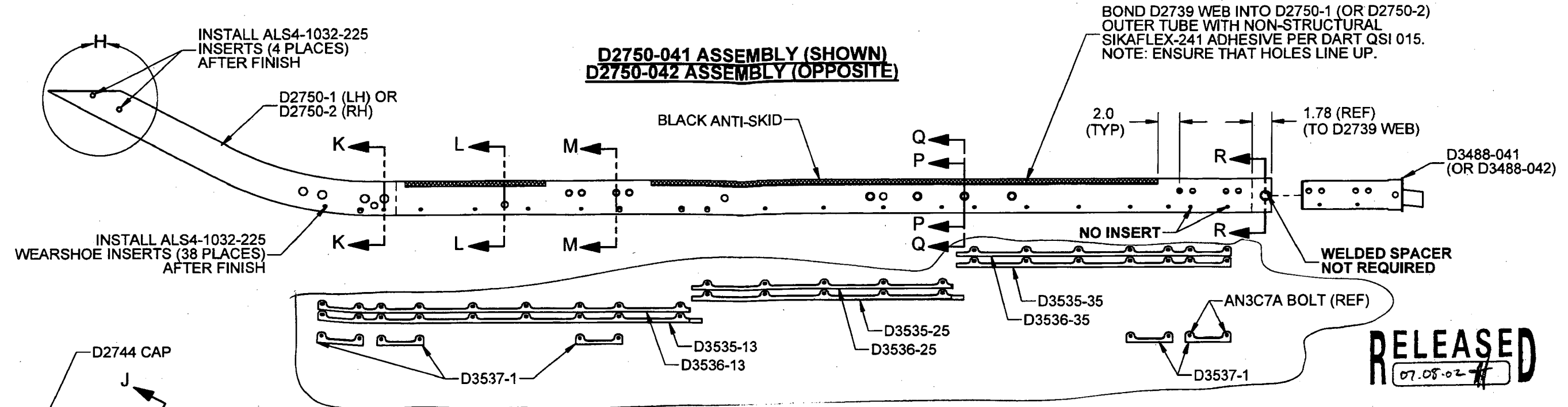


**RELEASED**  
 07-08-02

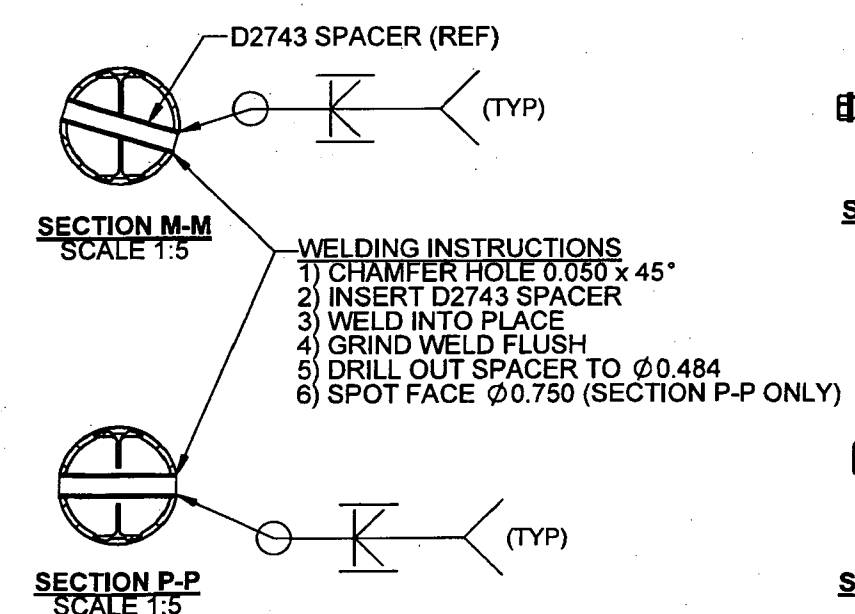
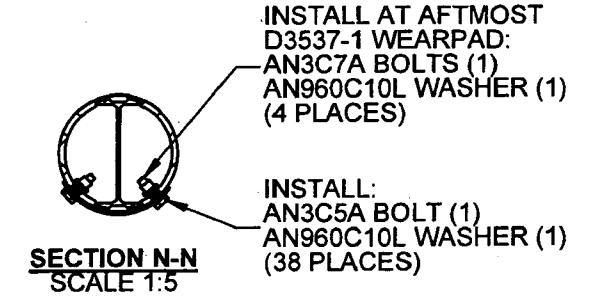
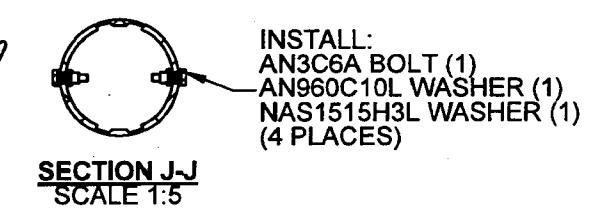


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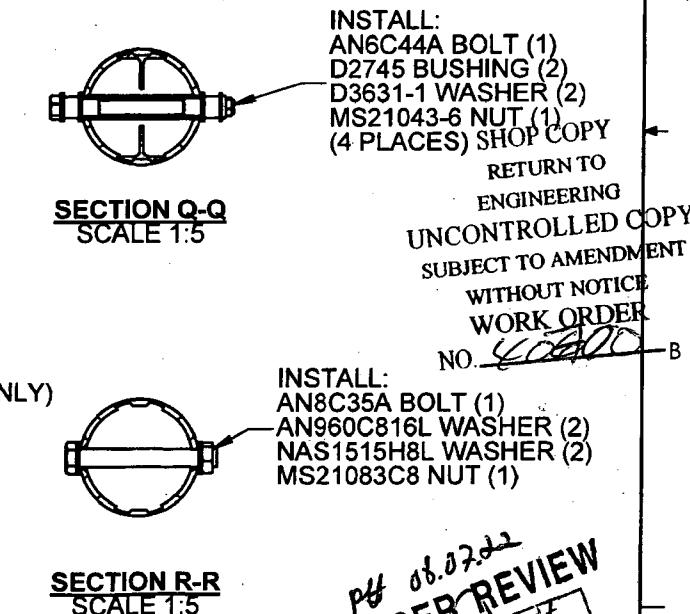
DESIGN PH	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED 	DRAWING NO. D2750	REV. E SHEET 3 OF 5
DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:20
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UPDATE  
PER ATTACHED  
DSI 9413  
PH  
07.07.22




- WELDING INSTRUCTIONS**
- 1) CHAMFER HOLE 0.050 x 45°
  - 2) INSERT D2743 SPACER
  - 3) WELD INTO PLACE
  - 4) GRIND WELD FLUSH
  - 5) DRILL OUT SPACER TO  $\phi 0.484$
  - 6) SPOT FACE  $\phi 0.750$  (SECTION P-P ONLY)



PH 06.07.22  
UNDER REVIEW  
07.05.22  
UPDATE  
PER  
DSI 9413

- WELDING INSTRUCTIONS**
- 1) CHAMFER HOLE 0.050 x 45°
  - 2) INSERT D3490-1 SPACER (4 PLACES) INTO  $\phi 0.500$  HOLES OR INSERT D3490-3 SPACER (4 PLACES) INTO  $\phi 0.750$  HOLES
  - 3) WELD INTO PLACE
  - 4) GRIND WELD FLUSH
  - 5) INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER OR INSERT D3492-043 PLUG ASSEMBLY (8 PLACES) INTO D3490-3 SPACER ON BOTH ENDS AFTER FINISH

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CHECKED PH	APPROVED 	DRAWING NO. D2750	REV. E SHEET 4 OF 5
DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:10
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